

Date: Monday, 3/17/2008 11:56:51 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	HELI ACCESS HANDLE WELDMENT ASS'Y, LH
Job Number	38024		
Estimate Number	10946		
P.O. Number	:	Part Number	D2480011
This Issue	: 3/17/2008	S.O. No.	D2480 REV A1
Prsht Rev.	: NC		N/A
First Issue	: / /	Type	LARGE FAB ASSY
Previous Run	: 36509		
Written By	:	Material	
Checked & Approved By	:	Due Date	3/31/2008
Comment	: Est. B1 03.01.09 added Powder Coat	Qty:	2
Um:	Each		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :					
1.0	D2478	Lower Arm					
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)					
		Lower Arm					
		Pick:					
		Qty	Part number	Description	Batch	B37462 → 1 ✓	
		1	D2478	Heli Access Handle		b34030 → 1 ✓	
2.0	D2479	Upper Arm					
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)					
		Upper Arm					
		Pick:					
		Qty	Part number	Description	Batch		
		1	D2479	Heli Access Handle		b34031 → 1 ✓ B33502 → 1 ✓	
3.0	D2481	Lower Mount Plate					
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)					
		Lower Mount Plate					
		Pick:					
		Qty	Part number	Description	Batch		
		2	D2481	Mounting Plate		b23503	
4.0	D2482	Upper Mount Plate					
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)					
		Upper Mount Plate					
		Pick:					
		Qty	Part number	Description	Batch		
		1	D2482	Mounting Plate		b14648	
			08/03/19				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No DQA:  Date: 01/03/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS HANDLE WELDMENT ASS'Y, LH

Job Number: 38024

Part Number: D2480011

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Template DT 8333 (DT 2480 CJ)

DD 08/03/19 (2X)

6.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-19 (2)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

OS/03/19 (2X)

8.0 POWDER COATING

POWDER COATING



M107005

(2X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

m-1 08/03/20

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



gf

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-20

(2)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Job# 37916

AS 08/03/24

(2)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

+ 08/03/24

Job Completion



U 8.3.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

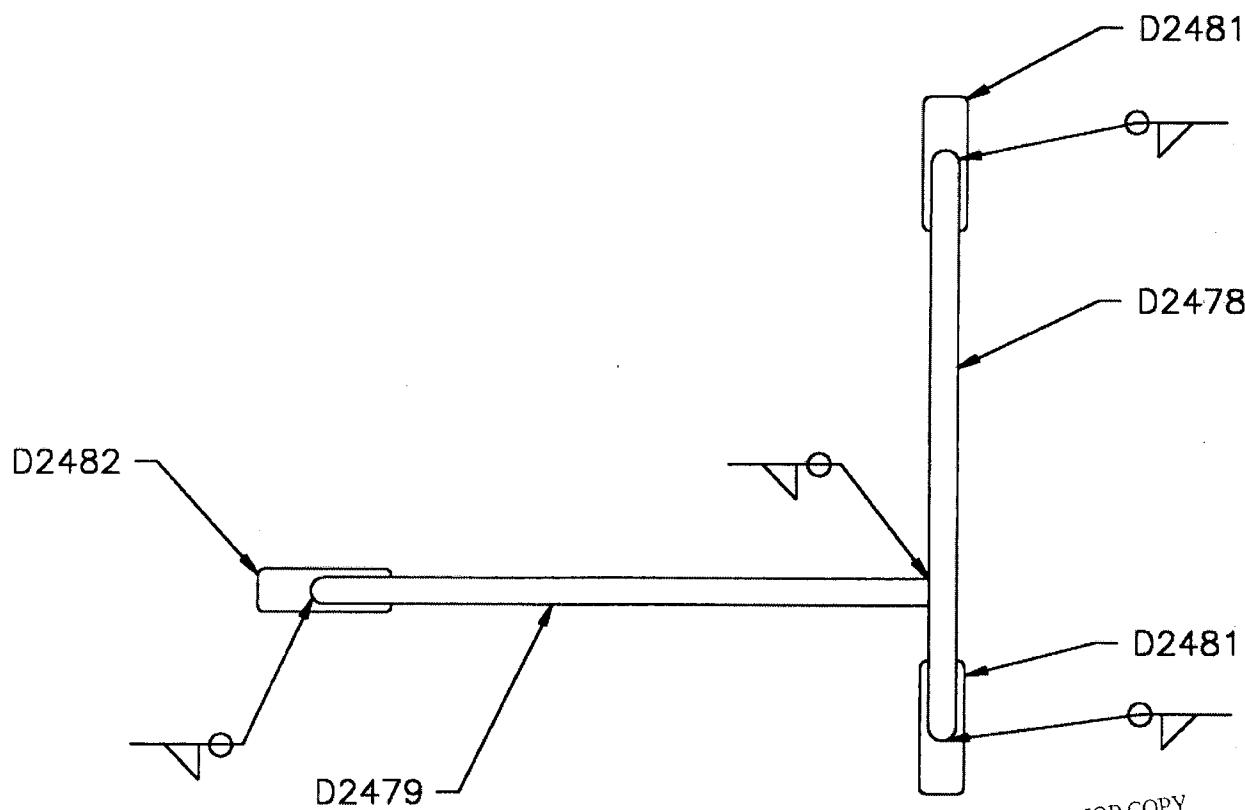
NOTE: Date & initial all entries



3 COPY AS  
GIVEN

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	MIKE M	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
BW	BW	D2480	SHEET 1 OF 1
DATE		TITLE	SCALE
96:05:14		HANDLE WELDMENT ASSEMBLY	6:1
A1	05.06.23	ADDED POWDER COAT	

RELEASED  
96/06/02 DS



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38024

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004  
A1 2) POWDER COAT WHITE GLOSS (REF: 4.3.5.2) AS PER QSI 005